

Work Order ID 67026

Thursday, March 03, 2011 11:56:23 AM



Page 1

Item ID: D3822-3KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, Aft Center-Grey

Start Date: 3/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: HDate: 11-03-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

2.

11/04/02

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 140Time IN: 4:30Time OUT: 7:00 AM

11/04/01

11/04/02

11/04/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 Thermoform Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA027 using tool DT9072 Dwg Rev: <u>C</u> Folio Rev: <u>C</u>	0.00 0.00				<u>2</u>			<u>B</u> 11/04/02
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect part for proper formation and texture	0.00 0.00				<u>2</u>			<u>B</u> 11/04/02
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>2</u>			<u>DL</u> 11/04/02

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandThermo	Memo	0.00				2			BB 11/04/07
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150 QC	QC2- Inspect parts off machine FAI/FAIB	0.00				2			BB 11/04/07
Quality Control	Memo Complete FAI document	0.00							
160 QC	QC5- Inspect part completeness to step on W/O	0.00				(x2)			
Quality Control	Memo	0.00							

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>158</u>	0.00							
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/4/18
MF
11-04-15

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Picklist Print

Thursday, March 03, 2011 11:56:29 AM

Page 1

Work Order ID: 67026

Parent Item: D3822-3KGY

Parent Item Name: Vertical Tunnel, Aft Center-Grey



Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

lpp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	188.6071	5.25	5.252626			



Kydex steel grey

Location

therm

111807

Loc Qty

188.607054

188.607054

Loc Code

10-5057
59 H

BB 11/04/07

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DART AEROSPACE LTD		Work Order: <u>07024</u>
Description: Vertical Tunnel, Aft Center		Part Number: D3822-3KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB Date: 11/04/07

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	.067	✓		VERN DL-02	
0.020	Min	.065	✓			
0.035	Min	.048	✓		VERN TH-DI	
0.4	Min	.429	✓			

Measured by: JB Date: 11/04/07
Audited by: SK Date: 11/04/07
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ <u>SK</u>	<u>JB</u>

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